

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029936**Date Inspected:** 23-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower ,OBG**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QA) Joe Adame arrived at the American Bridge/Fluor (ABF) JV job site between the times noted above in order to monitor ABF Quality Control activities and the in process work being performed by ABF production personnel. The following items were observed:

ESW Repair excavation

RWR-201308-003

ESW E-043, Location "Q"-Face A:

The QA Inspector was later present to observe ABF welder Donald Plumb (WID-0891) performing Shield Metal Arc Welding (SMAW) of the repair excavation on Electroslag Weld (ESW) "Q", at face B. Locations are listed as detailed in Request for Weld Repair (RWR) 201308-003 from Ultrasonic Testing indications designated for repair.

The repair locations were noted as:

Y= 3800mm~4300mm

L= 500mm

W= 80mm

D= 70mm

Prior to welding, Welder -0891 was observed preheating the weld to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder was using 4.0mm diameter electrode (E7018-1 HR4) per ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3. The welding parameters were verified by QC Inspector Bernie Docena with a Fluke 337 current clampmeter and preheat was verified with temperature indicators. Mr. Docena performed welding parameters verifications at random intervals throughout the shift. The welding observed appeared to be in compliance with the WPS noted above.

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## WELDING INSPECTION REPORT

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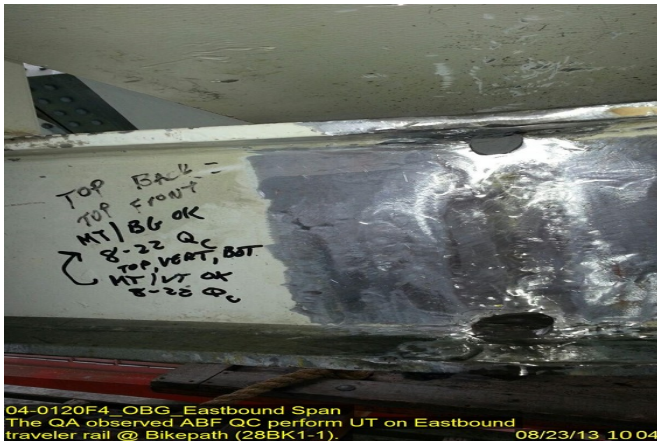
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UT Inspection of Maintenance Traveler Rail Splice

RFI-003407R0

Eastbound Maintenance Traveler Rail (28BK1-1) @ Bikepath

The QA Inspector observed ABF QC Inspector Bernie Docena perform 100% Ultrasonic Testing (UT) on Eastbound Maintenance Traveler Rail (28BK1-1) complete joint penetration splice. Mr. Docena stated that the work is being performed per ABF (RFI) Request For Information -003407R00. The QC Inspector also stated that the inspection is being performed per AWS D1.5-Table 6.3. The UT inspection was performed on approx. 526mm of top flange, bottom flange & web splice on the Traveler rail. The QA also performed UT of the above mentioned weld location in accordance with the applicable code requirements. Mr. Docena provided the QA Inspector with a courtesy copy of the NDT report. See TL-6027 for additional details on the items inspected on this date.



### Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to work and testing performed during this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Adame,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer

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